

Order ID 88027 -1

\*88027\*

Page 1

7-24-12 7:57:43 AM

Item ID: D3414-041

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Lug Assembly

Start Date: 7/24/12 Start Qty: 20.00

\*20\*

Cust Item ID:

Required Date: 8/03/12 Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/07/24 Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3414	Rev C

100

0.00

\*100\*

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3414-1

Dwg Rev: C

Prog Rev: C

304 .100

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

22 0 Jm 12-8-1

22 0 Jm 12-8-1



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Item ID: D3414-041

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**\*N900040100\***

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Start Qty: 20.00

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Approvals:

Process Plan:

Date:

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Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00	SmB 12-8-02	DAS 16 12/10/12		22 center			
130 <b>*130*</b> Brake NC Brake NC	Memo 1-Deburr 2-Form using DT8254 as per Dwg D3414	0.00 0.00				22			SA 12/08/15
140 <b>*140*</b> Large Fab Large Fab	Memo 1- Weld using location Jig DT9625 as per Dwg D3414 A/R S.S. welding rod Batch: 1217C C13	0.00 0.00				22			22 12-8-28

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Item ID: D3414-041

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\*N900040100\*

Setup Start \*NS1\*

Revision ID:

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Item Name: Lug Assembly

Start Date: 7/24/12

Start Qty: 20.00

\*20\*

Cust Item ID:

Required Date: 8/03/12

Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Run Start \*NR1\*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop \*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

\*150\*

QC

Memo

0.00

Quality Control

20

12.8.08

DAS 24 9-08

160

QC5- Inspect part completeness to step on W/O

0.00

\*160\*

QC

Memo

0.00

Quality Control

SMB

12.8.09

DAS 16 0.0

17/09/04

20

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

\*170\*

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11-10

400°F

11-40

20X

ML 12/09/04

M121841



**Work Order ID 88027**

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Item ID: D3414-041

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

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Item Name: Lug Assembly

Start Date: 7/24/12 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 8/03/12 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC3- Inspect Part Finish	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									
190	Identify as per dwg & Stock Location: <u>471</u>	0.00							
<b>*190*</b>									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
<b>*200*</b>									
QC	Memo	0.00							
Quality Control									

20x 4 11/08/01

20 12/09/04

12/9/5

ME  
12-09-04

# Picklist Print

July-24-12 7:57:43 AM

Page 1

Work Order ID: 88027

Parent Item: D3414-041

Parent Item Name: Lug Assembly

Start Date: 7/24/12

Required Date: 8/03/12

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A05.09.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S12GA  
304/316 0.100" Sheet

Purchased

No

100

sf

97.3700

0.155

3.1

Jun 12-8-

Location

Loc Qty

Loc Code

MAT019

97.37

113062

83.24

113077

14.13

113062

D3414-3

Manufactured

No

140

Each

24.0000

1

20

12-8-28

Lug

Location

Loc Qty

Loc Code

WA

20

83878

20

WA030

4

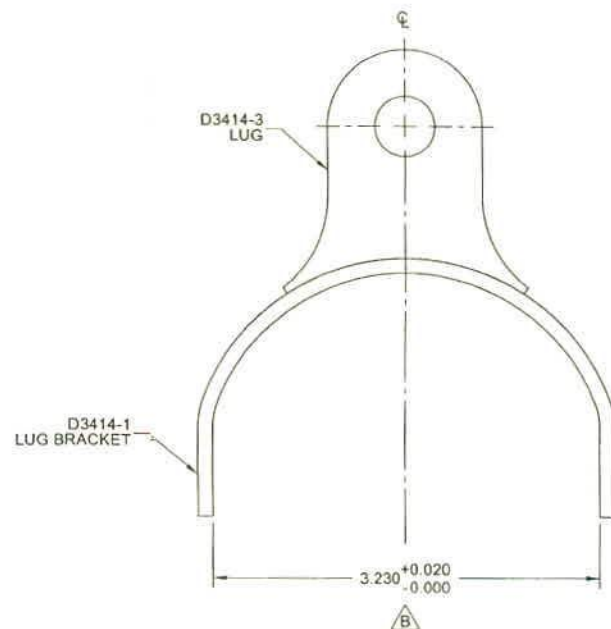
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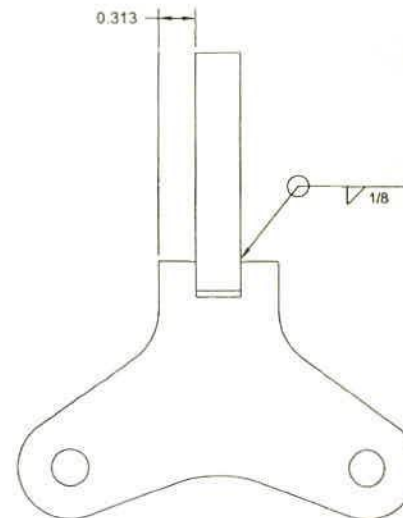
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22027



**D3414-041 LUG ASSEMBLY**

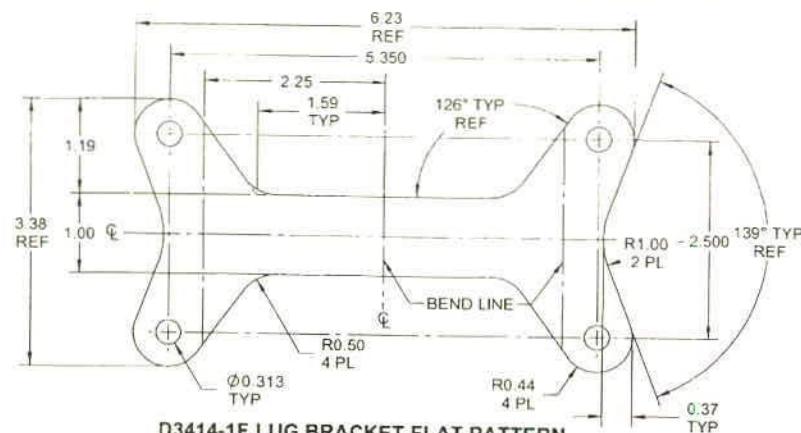


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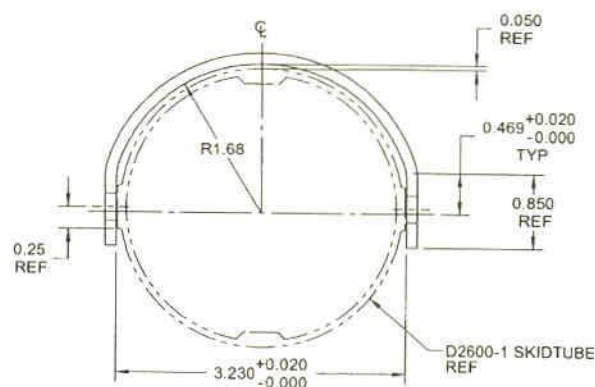
DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	CF		
CHECKED		DRAWING NO. <b>D3414</b>	REV. C
MFG. APPR.		SHEET 2 OF 3	
APPROVED		TITLE	SCALE
DE APPR		<b>LUG ASSEMBLY</b>	NTS
DATE	<b>09.06.17</b>	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



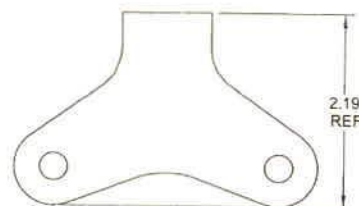




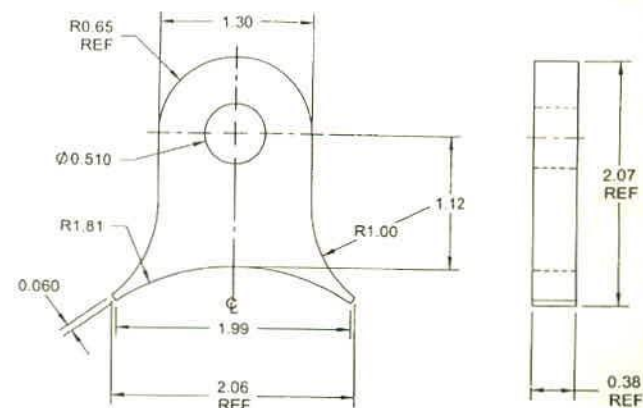
**D3414-1F LUG BRACKET FLAT PATTERN**



**D3414-1 LUG BRACKET**



**SIDE VIEW FOR REF ONLY**



**D3414-3 LUG**

**NOTES:**

1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S12GA

-3: AISI 304/316 STAINLESS STEEL PLATE  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: -1: 0.010 TO 0.020 MAX  
-3: 0.030 TO 0.060 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: N/A

**RELEASED**

DESIGN	QP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	QP		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D3414</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>LUG ASSEMBLY</b>	NTS
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